

Date: Monday, 09/02/2009 4:26:34 PM
 User: Mélanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD BLADE FOLD ASSEMBLY
Job Number	: 45644		
Estimate Number	: 13531		
P.O. Number	:	Part Number	: PB674300101
This Issue	: 09/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: B6743001 P.1, 2
First Issue	: //	Project Number	: N/A
Previous Run	: 45643	Drawing Revision	: B1
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 29/04/2009
Checked & Approved By	: <u>MF 09-03-12</u>	Qty:	2 Um: Each
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300107	Fwd Blade Fold Assembly Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Fwd Blade Fold Assembly Weldment
 batch: B45049

Cpl 09.03.13

2.0	PB674300115	Fwf Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Fwf Adjustable Blade Support Assembly
 batch: B45041

Cpl 09.03.13

3.0	PB674300111	Fwf Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Fwf Adjustable Blade Support Assembly
 batch: B45043

Cpl 09.03.13

4.0	PB674300121	PB67-43001-21
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 PB67-43001-21
 batch: B45038

Cpl 09.03.13

5.0	PB674300123	PB67-43001-23
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 PB67-43001-23
 batch: B45035

Cpl 09.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: PB674300101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB674300145	Longitudinal Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Support Assembly

batch: B45028

Cpl 09.03.13

7.0	PB674300151	Long T-Handle Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Long T-Handle Assembly

batch: B45026

Cpl 09.03.13

8.0	PB6743001261	Lever Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lever Arm

batch: B43093 (x3) B44978 (x1)

Cpl 09.03.13

9.0	PB6743001265	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

batch: B41373 (x7) B44977 (x1)

Cpl 09.03.13

10.0	PB6743001299	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

batch: B40062

Cpl 09.03.13

11.0	D3451041	Handle and Lock-Down Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: B46077

Cpl 09.03.13

12.0	D3451047	Handle and Lock-Down Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: B45710

Cpl 09.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 45644

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D34473

Square Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Square Spacer

batch: B45016

Ppl09.03.13

14.0

D34477

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clevis

batch: B43926

Ppl09.03.13

15.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Swing Arm

batch: B41352

Ppl09.03.13

16.0

D3445041

Belt Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Belt Assembly

batch: B41350

Ppl09.03.13

17.0

086004

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inventory

batch: M109350

Ppl09.03.13

18.0

MS27039104

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inventory

batch: m18431

Ppl09.03.13

19.0

MS27039123

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

batch: m18057

Ppl09.03.13

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 45644

Part Number: PB674300101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
batch: m10399

Cpl 09.03.13

21.0	MS21042L4	Nut
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)
Nut
batch: m109282

Cpl 09.03.13

22.0	MS21042L6	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Nut
batch: m108183

Cpl 09.03.13

23.0	MS518596	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
WASHER
batch: m108473

Cpl 09.03.13

24.0	MS518598	WASHER
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Comment: Qty.: ~~8.0000~~ Each(s)/Unit Total : ~~16.0000~~ Each(s)
WASHER
batch: m108286 (x8) ¹⁶ m11060 (x8)
or MS51859-7 (see engineering) batch: m106421 4 each 8 total

Cpl 09.03.13

25.0	NAS43DD368	SPACER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
SPACER
batch: m109060

Cpl 09.03.13

26.0	NAS1149F0316P	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER
batch: m11117

Cpl 09.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 45644

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch: m18057

LpC09.03.13

28.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m18057

LpC09.03.13

29.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m18057

LpC09.03.13

30.0

AN960JD6

Washer



Comment: Qty.: ~~4~~ 6.0000 Each(s)/Unit Total : ~~4~~ 12.0000 Each(s)

Washer

batch: m6085

LpC09.03.13

31.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: m107178

LpC09.03.13

32.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: m110865

LpC09.03.13

33.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: _____

or AN415A (see engineering) batch: m110399

309.03.17

LpC09.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 45644

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

batch: m105558

Pl 09.03.13

35.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch: _____

or AN6C16A (see engineering) batch: m105831

Pl 09.03.13

36.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

batch: m18180

Pl 09.03.13

37.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

RIVET

batch: m109119

Pl 09.03.13

38.0

CR3213405

cherry rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

cherry rivet

batch: m104214

Pl 09.03.13

39.0

MS17984C408

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

PIN, QUICK RELEASE

batch: m108986

or MS17984C410 (see engineering) batch: _____

Pl 09.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 45644

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

PIN, QUICK RELEASE

batch: m108986

Cpl 09.03.13

41.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

8" LANYARD

batch: m108973

Cpl 09.03.13

42.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

LANYARDS

batch: m108973

Cpl 09.03.13

43.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

SPRING SLOTTED PIN

batch: m111088

Cpl 09.03.13

44.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: m109687

Cpl 09.03.16

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/16

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PP 45604


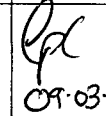
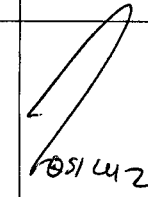
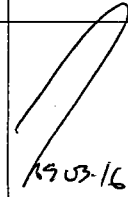

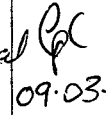
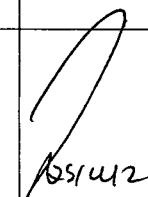
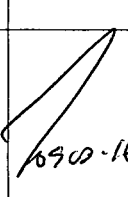
09/2/17

1527039-1-06 XX

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-01 PAR #: N/A Fault Category: Prod/Ins. Large NCR: Yes No DQA: D Date: 09/03/16
 Resolution: re-work Disposition: re-work QA: N/C Closed: D Date: 09/03/16

NCR: <u>45644</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-03-16	44.0	upon transfer drilling through the -15 arm; -05 tube, for the locking pop-pin the hole on the inner side was slightly oversized. R.C: Human error.	 09/03/16	Grind & flush : fill affected hole with weld per AS1004, Grind weld on the inside of the tube flush. - Touchup the outside with the matching color.	 09-03-16	S 09/03/16	 09/03/16	 19-03-16
			 09/03/16	Re-transfer drilled affected hole as per dwg.	 09-03-16	S 09/03/16	 09/03/16	 19-03-16

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 45644

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/17 *MF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-03-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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